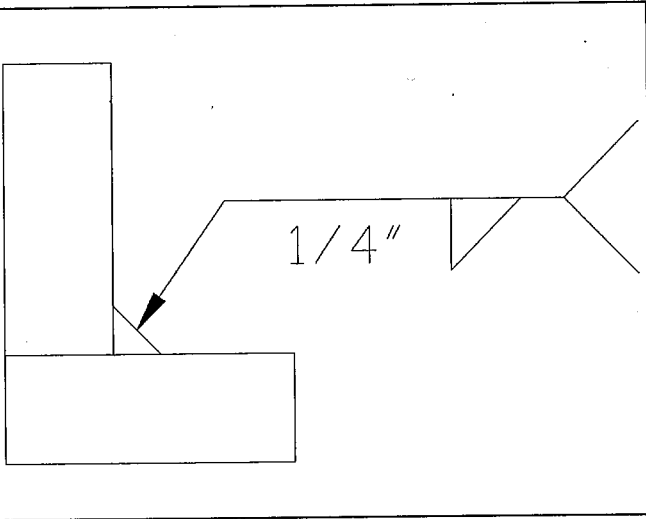


WELDING PROCEDURE SPECIFICATION

Material Specification	A709 TO A500 GR B		
Welding Process	FCAW		
Manual or Machine	SEMAUTOMATIC		
Position of Welding	FLAT		
Filler Metal Specification	A5.20 - 95		
Filler Metal Classification	E71T-1H8 E71T-9H8 LINCOLN ULTRACORE		
Flux	N/A		
Shielding Gas	CO 2	Dew Point	-40DEG F Flow Rate 50CFH
Single or Multiple Pass	SINGLE		
Single or Multiple Arc	SINGLE		
Welding Current	DC		
Polarity	REVERSE ELECTRODE POSITIVE		
Welding Progression	STRINGER		
Root Treatment	D1.5		
Preheat and Interpass Temperature	D1.5		
Postheat Temperature	NONE		
Heat Input	Min		Max

WELDING PROCEDURE

Pass no.	Electrode size	Welding Current		Travel speed	Joint detail
		Amperes	Volts		
1	1/16	300	26	14	
Variable	LIMITS	270	24	12.6	
		TO	TO	TO	
		330	28	15.4	

This procedure may vary due to fabrication sequence, fit-up, pass size, etc., within the limitation of variables given in Section 5.

Procedure No. 3009
Revision No. _____

Contractor Elderlee, Inc.
Authorized By RANDY SCOTT
Date 5/22/2013